

Date: Thursday, 15/01/2009 11:15:11 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 44818		
Estimate Number	: 12705		
P.O. Number	:	Part Number	: D35723
This Issue	: 15/01/2009 S.O. No. :	Drawing Number	: D3572 REV.C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 40562	Material	:
Written By	:	Due Date	: 10/02/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>JLD 09.01.15</u>		
Comment	: Est Rev:A New Issue 07-02-07 JLM est rev B rev.B dwg EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X01500	6061-T6 Bar .750 X 1.50
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Comment: Qty.: 0.0431 f(s)/Unit Total: 0.4305 f(s)

6061-T6 Bar .750" X 1.500"

Batch: M 110107

DTP 09/01/18

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank .500" long

DTP 09/01/18

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA685 Rev: AA & Dwg D3572 Rev: C

(10)

2-Deburr per dwg D3572

DTP 09/01/19

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DTP 09/01/19

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

m 09/01/19

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 15/01/2009 11:15:11 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 44818

Part Number: D35723

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Carl*

*SS 09/01/20 (CB)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/01/21 JF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*h 09.01.20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

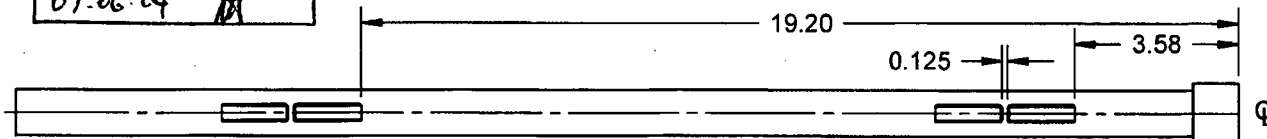
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3572</b>	REV. C SHEET 1 OF 2
DATE <b>07.06.01</b>	TITLE <b>GUIDE ASSEMBLY</b>		SCALE 1:4
REV	DATE	DESCRIPTION	
A	07.03.29	NEW ISSUE	
B	07.04.20	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	
C	07.06.01	REMOVE D3572-7	

**RELEASED**07.06.04 *H*D3572-3 GUIDE  
(4 PLACES)

3/16

4X

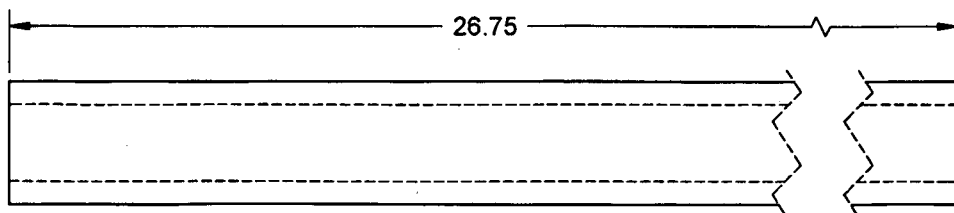
D3572-1 TUBE

**D3572-041 GUIDE ASSEMBLY**

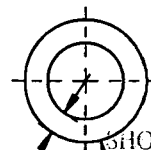
D3572-5 BRACKET

**D3572-041 NOTES:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

**D3572-1 TUBE****D3572-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



0.188 (REF)  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

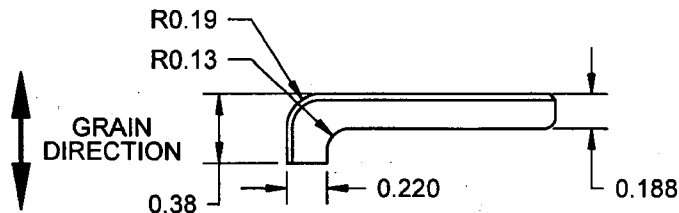
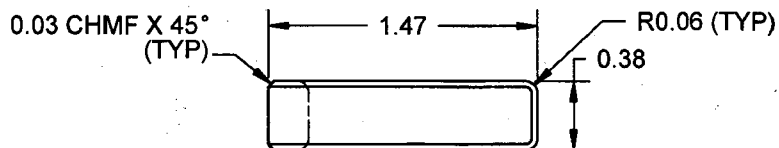
SHOP COPY  
RETURN TO  
ENGINEERING  
WORK ORDER  
NO. *44818*

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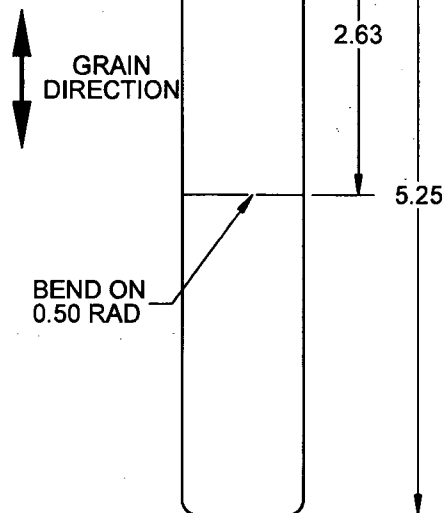
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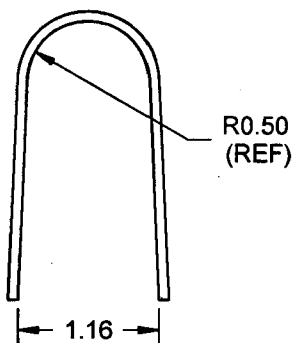
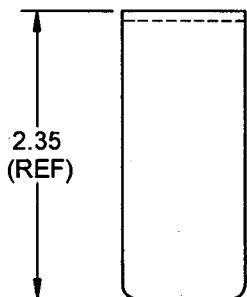
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3572</b>	REV. C SHEET 2 OF 2
DATE <b>07.06.01</b>		TITLE <b>GUIDE ASSEMBLY</b>	SCALE 2:3



1 **D3572-3 GUIDE**



2 **D3572-5F FLAT PATTERN**



**D3572-5 BRACKET**  
**(MAKE FROM D3572-5F)**

**RELEASED**

*07.06.01*

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

**D3572-3/-5 NOTES:**

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 (OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080))
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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